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DATA SHEET **ENV 801a – Cleaning recommendations for by ENVIRAL[®] Oberflächenveredelung GmbH powder coated facade elements**

Proper cleaning of powder coated facades is required in order to

- preserve the decorative appearance of the façade
- reduce the corrosion load

It is recommended that regular inspections are carried out - usually at least once a year, or more frequently in the case of severe environmental stresses. In this way, any damage can be detected at an early stage and remedied in a timely manner using suitable measures.

If a coated component becomes soiled due to transport, storage or assembly, the surface is to be cleaned with clear water - cold or lukewarm. Neutral or slightly alkaline cleaning agents can be used for stubborn soiling.

Cleaning must be carried out in accordance with the following guidelines and the current GRM data sheets:

1. Pure water, also with small additions of neutral or very slightly alkaline detergents. By using soft, non-abrasive cloths or rags, an additional mechanical cleaning effect can be achieved.
2. The surface temperature of the facade elements must not exceed 25°C during cleaning.
3. The cleaning agents may also only be used in a cold state (max. 25°C). Do not use steam jet equipment!
4. Do not use acidic or strongly alkaline cleaning and wetting agents.

5. Do not use abrasive, scratching agents. Use only soft cloths or industrial cotton for cleaning. Do not rub vigorously.
6. Do not use organic solvents containing esters, ketones, alcohols, aromatics, glycol ethers or halogenated hydrocarbons or such.
7. Do not use cleaning agents of unknown composition.
8. Greasy, oily or sooty substances can be removed with aromatics-free benzene hydrocarbons. Preliminary tests must be carried out on non-visible surfaces. Residues of adhesives, silicone rubber or adhesive tapes etc. can also be removed in this way. Immediate removal is important.
9. The maximum exposure time of these cleaning agents must not exceed one hour; after at least 24 hours - if necessary - the cleaning process can be repeated.
10. Immediately after each cleaning process, rinse with clean, cold water.

Quality assured facade cleaning:

Cleaning MUST be carried out in accordance with the current guidelines of the "Gütegemeinschaft Reinigung von Fassaden" e.V. (GRM).

Quality-assured facade cleaning in accordance with RAL-GZ 632 requires the use of neutral cleaning agents (pH 5 - 8) that have been tested by the "Gütegemeinschaft für die Reinigung von Metallfassaden" e.V. (GRM). Cleaning is carried out in accordance with the division into cleaning classes in specified cleaning steps.

For matt and finely textured surfaces, special cleaning MUST be carried out in accordance with GRM Leaflet 07 "Cleaning of matt and textured coated metal surfaces" in the latest version.

Additional advice on maintenance and cleaning can be obtained from, among others:

Gesamtverband der Aluminiumindustrie e. V. (GDA)
Fritz-Vomfelde-Straße 30
D-40547 Düsseldorf
<http://www.aluinfo.de> (Aluminum Leaflet A05 "Cleaning of aluminum in construction")

Gütegemeinschaft für die Reinigung von Metallfassaden e.V. (GRM)
Alexander-von-Humboldt-Str. 19
D-73529 Schwäbisch Gmünd
<https://www.grm-online.de>

American Architectural Manufacturer's Association
USA, (AAMA 610-1979 Cleaning Procedures)
<https://aamanet.org/>